

Eastwood

DO THE JOB RIGHT.

Item #14042

VERSA-BEND™ 20" OFFSET SHEET METAL BRAKE INSTRUCTIONS



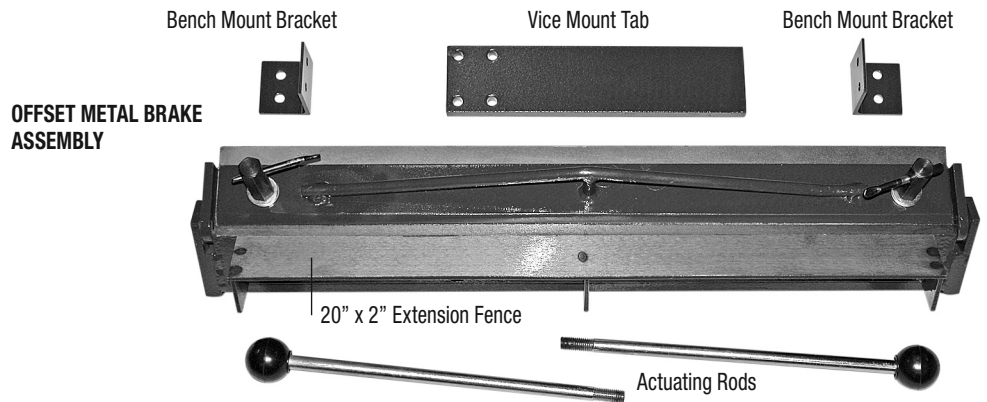
The **EASTWOOD VERSA-BEND™ 20" OFFSET SHEET METAL BRAKE** is a precision engineered metal working tool designed to produce both standard variable length bends as well as accurate ½" offset bends up to 90° in mild, 20 gauge sheet steel and 18 gauge aluminum in widths up to 20". Also capable of creating bends in 18 gauge steel in widths less than 12". Create floor reinforcement channels and ribs, sections of corrugated pickup bed floors; truck bedside panels, inner fender structures and much more all with one convenient vise or bench mount tool.

WARNINGS

- This tool is considerably heavy. Use extreme caution when mounting or dis-mounting when using a vice or other temporary fixturing arrangement. Personal injury could occur if tool is dropped.
- **PINCH HAZARD!** Keep fingers and away from moving parts when operating.
- Wear appropriate work gloves and protective clothing. Sheet metal will often have sharp edges which can cause cuts to hands and arms.
- Wear appropriate eye protection. Metal chips can be ejected during the bending process.

INCLUDES

- (1) Offset Metal Brake Assembly
- (2) Actuating Rods
- (1) Vice Mount Tab and Hardware
- (2) Bench Mount Brackets and Hardware



ASSEMBLY

- Assemble the two Actuating Rods to the pivoting Bending bar by inserting threaded ends into the threaded holes and tighten firmly.

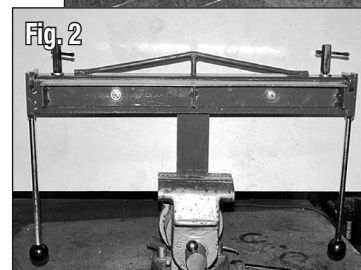
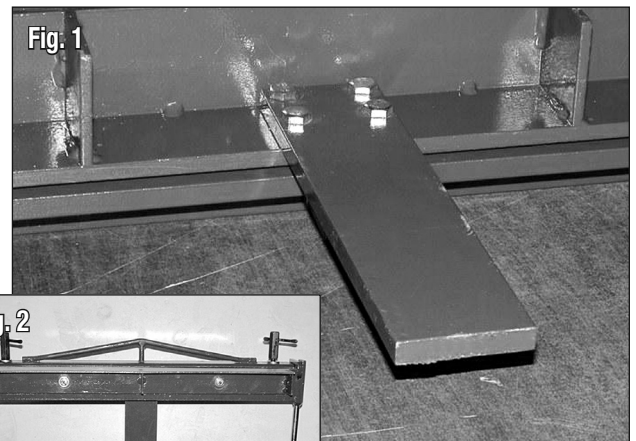
SET-UP

VICE MOUNTING

- Attach the supplied Vice Mount Tab by bolting in place on the brake body and tighten the four bolts (included) securely (Fig 1).
- Using a 6" or larger vice, place the assembled unit with the vice mount tab pointing downward and between vice jaws. Be sure to firmly tighten vice jaws to prevent tool movement (Fig 2).

BENCH-TOP MOUNTING

- Attach the (2) supplied bench mount flanges by bolting in place on the brake body sides and tighten bolts (included) securely (Fig 3).
- Using suitable lag bolts or through bolts and nuts, securely bolt the flanges to the work surface to prevent tool movement. Large "C" clamps may also be used.



OPERATION

STANDARD BENDS UP TO 90°

With the 2" x 20" Extension Fence in place on the Bending Bar, conventional bends can be made in 20 gauge mild steel panels up to 20" wide and 18 gauge in widths of 12" or less. To do so;

- Measure and mark the desired bend line on your sheet metal panel.
- Loosen the Clamping Beam Hold-down T-Screws. A 17mm wrench may also be used.
- Slide panel under the Clamping Beam lining up your pre-marked bend line with the lower, beveled edge of the Clamping Beam. Note: this edge is set back slightly from the main body of the brake to allow for a sufficient bend radius of the metal and the most accurate bends (Fig 4).
- Tighten the Clamping Beam Hold-down T-Screws to hold the panel in place. A 17mm wrench may also be used.
- Grasping both handles of the moveable Bending Bar, lift upward, bending your panel until the desired bend angle is achieved.

NOTE: The use of an angle gauge or protractor (not included) is recommended (Fig 5).

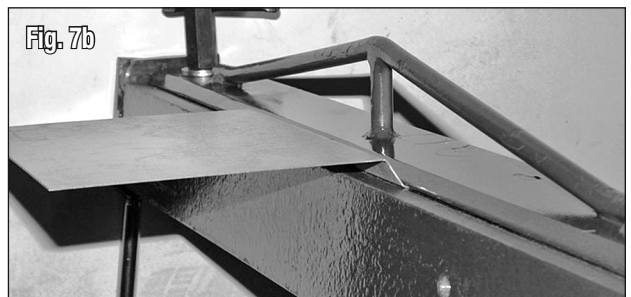
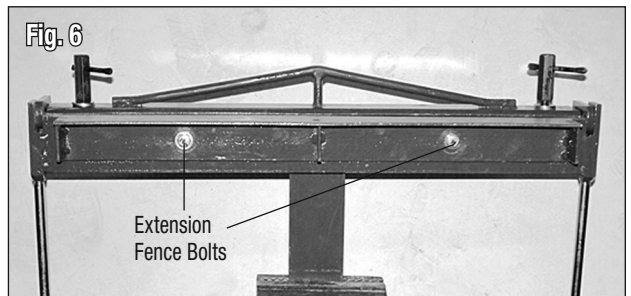
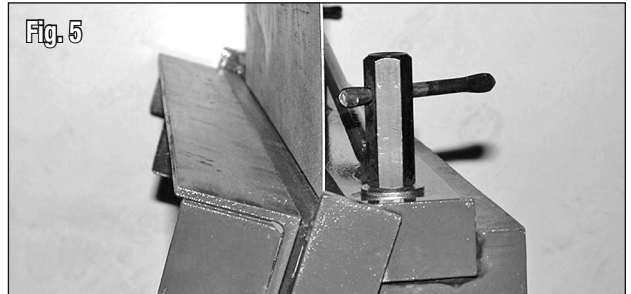
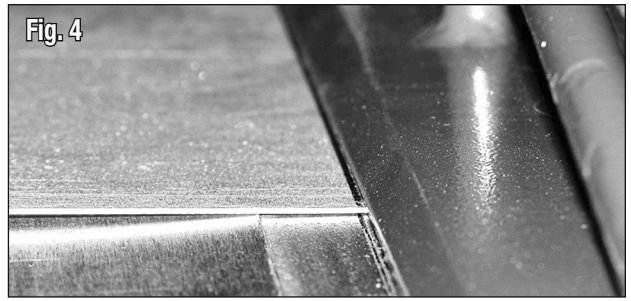
- Depending on the particular alloy being bent, it may be necessary to rotate the Bending Bar slightly beyond the desired angle to allow for "springback". Some trial and error is suggested in scrap material before making final bends.

OFFSET "JOGGED" BENDS UP TO 90°

With the 2" x 20" Extension Fence removed from the Bending Bar, 1/2" offset bends can be made in 20 gauge mild steel panels up to 20" wide and 18 gauge in widths of 12" or less.

NOTE: It is strongly recommended to make a mockup of your final piece in heavy construction paper or manila folder material prior to beginning as it is very easy to make a mistake and create a bend in the wrong direction.

- Loosen and remove the 2 bolts securing the 2" x 20" Extension Fence to the Bending Bar.
CAUTION! This Extension Fence is heavy and may cause personal injury if dropped. Use care to support it during removal (Fig 6).
- Measure and mark the desired bend lines on your sheet metal panel.
- Loosen the Clamping Beam Hold-down T-Screws. A 17mm wrench may also be used.
- Slide panel under the Clamping Beam lining up your pre-marked bend line with the lower, beveled edge of the Clamping Beam.
NOTE: this edge is set back slightly from the main body of the brake to allow for a sufficient bend radius of the metal and the most accurate bends (Fig 4).
- Tighten the Clamping Beam Hold-down T-Screws to hold the panel in place. A 17mm wrench may also be used.
- Grasping both handles of the moveable Bending Bar, lift upward, bending your panel until the desired bend angle is achieved.
NOTE: The use of an angle gauge or protractor (not included) is recommended.
- Depending on the particular alloy being bent, it may be necessary to rotate the Bending Bar slightly beyond the desired angle to allow for "springback". Some trial and error is suggested in scrap material before making final bends.
- For successive bends, loosen the Clamping Beam, flip the panel over, place in under the Clamping Beam then repeat steps outlined above. (Fig 7a, 7b, 7c).



TOOL MAINTENANCE

- Provide several drops of oil to pivot points periodically to prevent binding.
- Keep all areas of the tool clean particularly those surfaces that contact Sheet metal work pieces. Dirt and metal chips can cause uneven clamping and inaccurate bends.
- Store in a clean & dry environment when not in use. Coat all machined surfaces with a light lubricant film of oil or suitable protectant to prevent rust formation.

ACCESSORIES

- #28038 Sheet Metal Gauge
- #13475 Electric Metal Cutting Shears
- #28187 Bead Roller Kit
- #51088 Shrinker/Stretch Set

If you have any questions about the use of this product, please contact

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